

Date: Wednesday, 9/27/2006 11:04:31 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SPACEPOD ASSEMBLY RH |
| Job Number | : 28742 | | |
| Estimate Number | : 10799 | | |
| P.O. Number | : <u>N/A</u> | Part Number | : D350600142 |
| This Issue | : 9/27/2006 | S.O. No. | : <u>N/A</u> |
| Prsht Rev. | : NC | Drawing Number | : D3188/ICA-D350-600 |
| First Issue | : <u>N/A</u> | Project Number | : N/A |
| Previous Run | : 27494 | Drawing Revision | : A/2 |
| | Type : SMALL /MED FAB | Material | : <u>N/A</u> |
| Written By | : <u>[Signature]</u> | Due Date | : 10/15/2006 |
| Checked & Approved By | : <u>[Signature]</u> | Qty: | 1 Um: Each |
| Comment | : Est Rev: D 06.04.14 Incorporated procedures from D3187-1/-2 K J/JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-142 CHG002

K-3 06.08.02 ①

| | | |
|-----|--------|------------------|
| 2.0 | 28742A | SPACEPOD BODY RH |
|-----|--------|------------------|



Comment: Sub-Component SPACEPOD BODY RH
 D3188-2 B [checkmark]

| | | |
|-----|--------|------------------|
| 3.0 | 28742B | SPACEPOD DOOR RH |
|-----|--------|------------------|



Comment: Sub-Component SPACEPOD DOOR RH
 D3186-2 B 28742 B

mloc/11/09

| | | |
|-----|--------|----------------|
| 4.0 | D31872 | Spacepod Floor |
|-----|--------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 1 | D3187-2 | Floor | <u>B25405</u> |
| 1 | D3186-2 | DOOR (REF) | <u>B28742B</u> |
| 1 | D3188-2 | BODY (REF) | <u>B28742A</u> |

mloc/11/09

| | | |
|-----|-------------|--------|
| 5.0 | ALS41032130 | Insert |
|-----|-------------|--------|



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|---------------|-------------|---------------|
| 28 | ALS4-1032-130 | Insert | <u>m18293</u> |

mloc/11/09

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE | CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-2. Open holes in floor to Ø0.297". Install inserts as per Dwg D3188.

ml 06/11/09

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3187-2 as per Dwg 3187

2-Deburr D3187-2

ml 06/11/09

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/09 (D)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 11 09 (D)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

ml 0700

FC

06 11 09 (D)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/11/10 (D)

12.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

5.62SF D2986

Neoprene Foam

B24628

✓

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

06/11/09

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

1100371

SAD

08:11:09

(1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/14/10 (1)

15.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 -D2179 Hinge Bracket Plate

326077

16.0

D2219

Door Prop Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2219 Door Support Bracket

314027

17.0

D2228

Backing Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2228 Backing Plate

B24560

18.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2237 Strike Plate

B27195

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Job Number: 28742

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2464

3/4 Seal



Comment: Qty.: 10.9305 f(s)/Unit Total : 10.9305 f(s)

Pick:

Qty Part Number Description Batch

1 D2464-125" neoprene Seal B28812

✓

20.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch B29021

✓

21.0

D2588

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Chanel

Batch: B21509

✓

22.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Key Chain

Batch: B26031

✓

23.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2621 Latch Plate B27252

✓

24.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-1 Hinge Bracket B26209

✓

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Job Number: 28742

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Hinge Bracket B264087

26.0

D2977

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2977 Hinge Bracket B314106

27.0

D2978

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2978 Hinge Bracket B314107

28.0

D2982041

Prop Arm Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2982-041 Prop Arm Assembly B25476

29.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock Nut B22365

30.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 A3235-020-935 Washer M100477

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN526C832R9

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN526C832R9 Screw M100447

✓

32.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M100743

✓

33.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer M15927

✓

34.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 AN960JD8 Washer M11989

✓

35.0

AN960JD8L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer M6956

✓

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Job Number: 28742

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS20426AD45

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 MS20426AD4-5 Rivet M 3459

✓

37.0

MS21042L08

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

14 MS21042L08 Nut (or -8) M19633

✓

38.0

MS21042L3

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS21042L3 Nut (or -3) M15539

✓

39.0

MS270390810

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0810 Screw M5865

✓

40.0

MS27039125

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039-1-25 Screw M17570

✓

41.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 SL69-BS Ball Stud M16948

✓

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Part Number: D350600142

Job Number:



Seq. #: Machine Or Operation: Description :

42.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

ml 06/11/09

43.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 06/11/10 ①

44.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188-2 & QSI 005 4.4

Batch: *ml 02 0918*

FC 06 11 09 ①

45.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

ML 06/11/10 ①

46.0 K10018 Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

B28748

1 D3187-2(Ref)

Spacepod Floor

B25405

ML 06/11/10

47.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ML 06/11/10

48.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location: *C*

PPP Rev: *C*

ML 06/11/10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20611.10

Job Completion



U 26.11.10

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

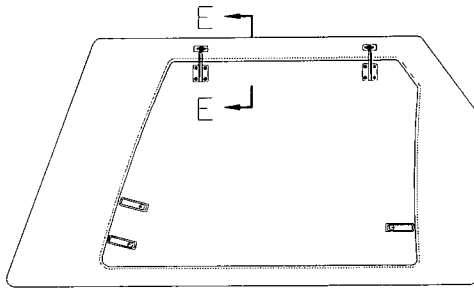


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

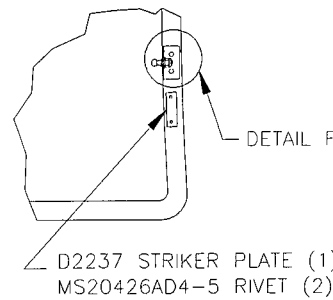


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

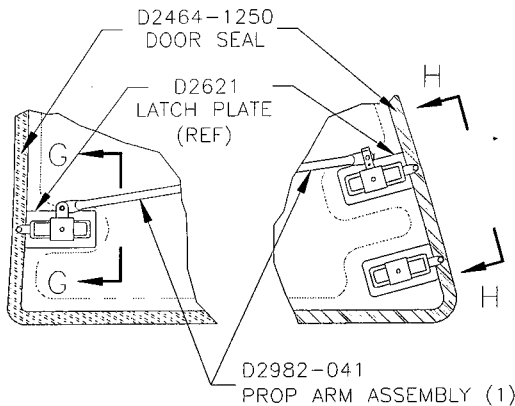
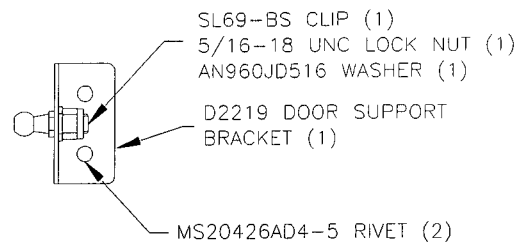


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

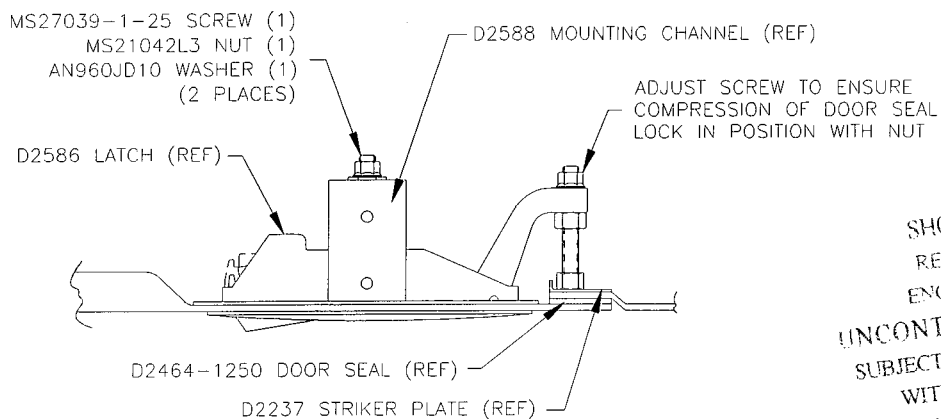
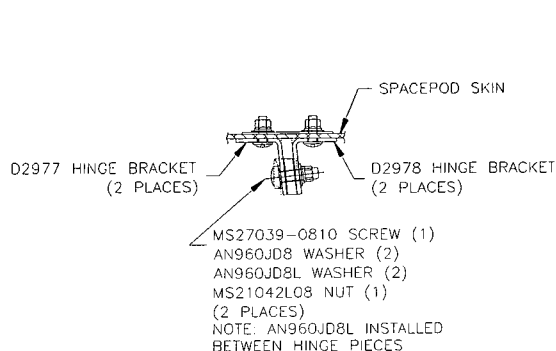


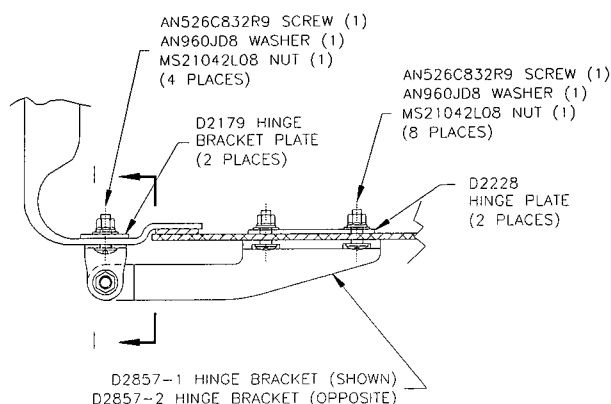
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 28742

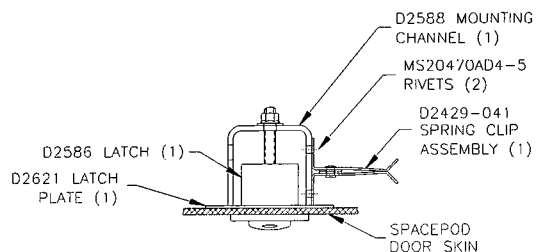
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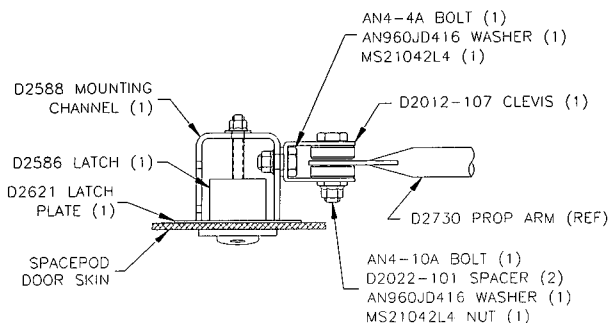
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

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TC Accepted
MAY 07 2003

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| DATE 03.04.03 | | TITLE SPACEPOD BODY | SCALE NTS |
| A | 03.04.03 | NEW ISSUE | |

RELEASED
#-0304.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

| <u>PART</u> | <u>LAYUP</u> | <u>TRIM AND DRILL</u> |
|-------------|--------------|-----------------------|
| D3188-1 | DT8003 | DT8501 |
| D3188-2 | DT8004 | DT8502 |
| D3188-3 | DT8500 | DT8501 |

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

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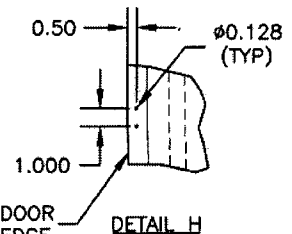
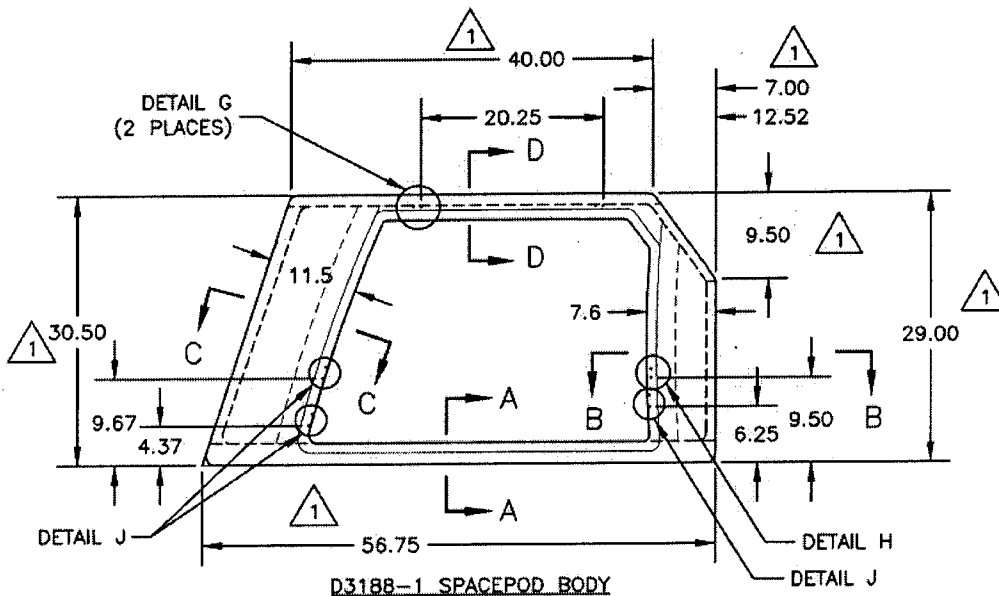
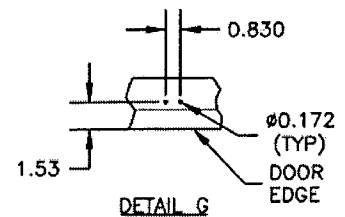
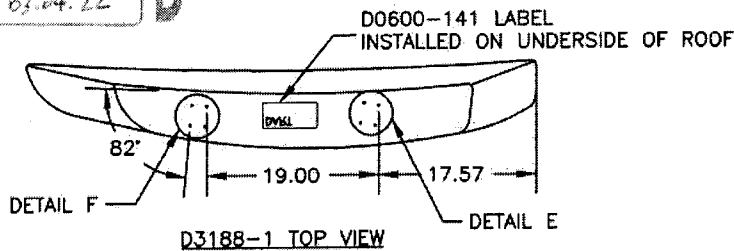
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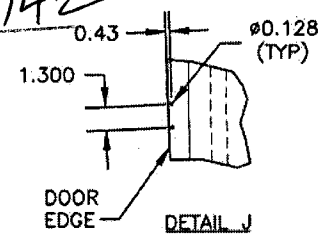
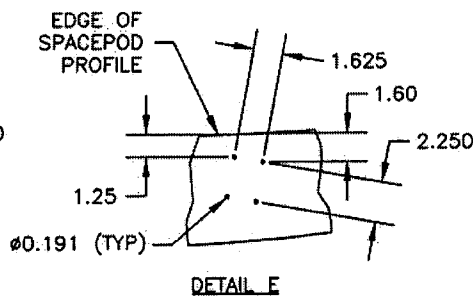
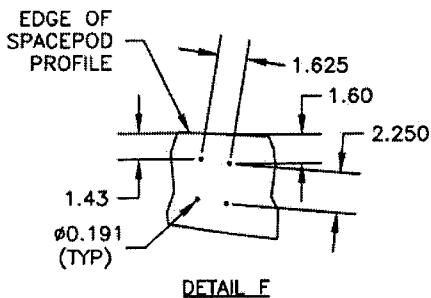


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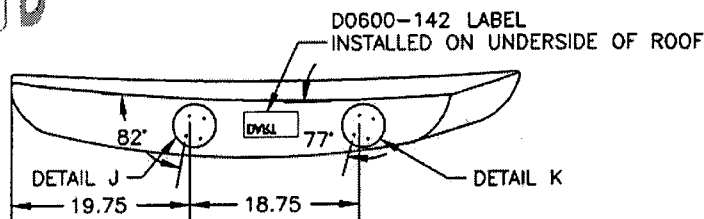
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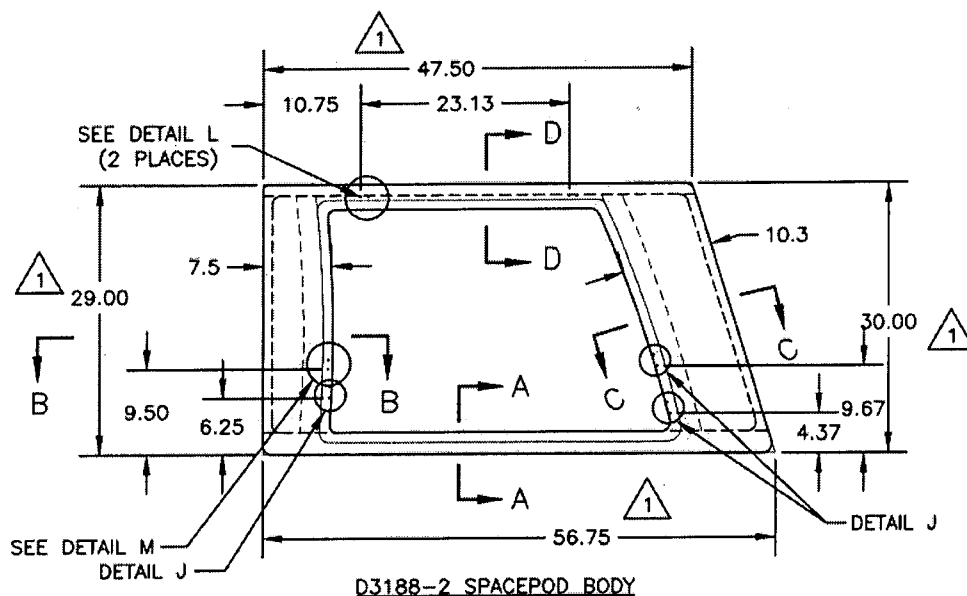


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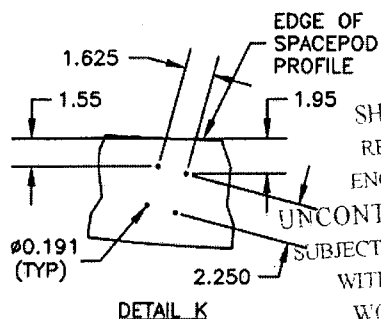
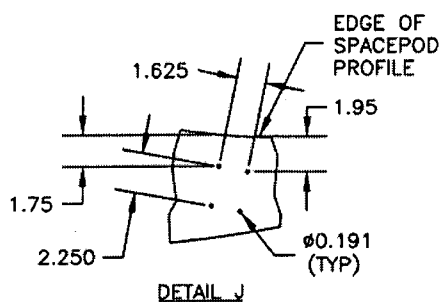
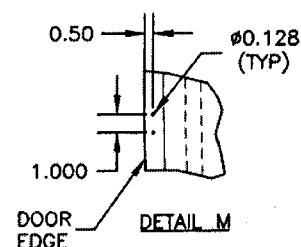
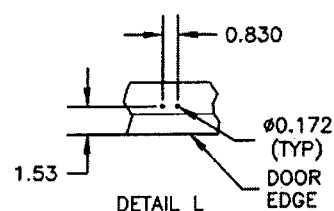
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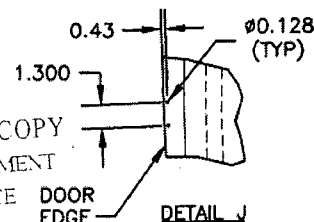
D3188-2 TOP VIEW



D3188-2 SPACEPOD BODY



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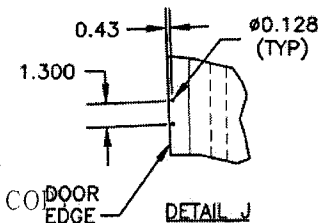
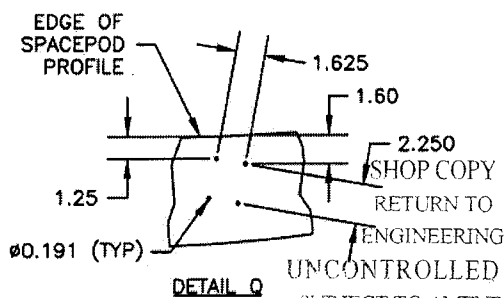
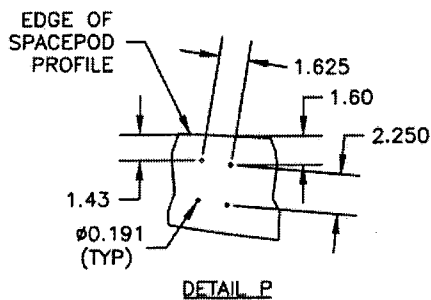
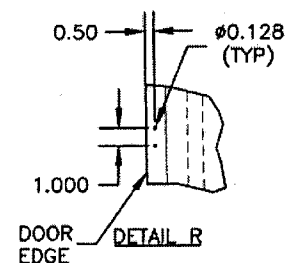
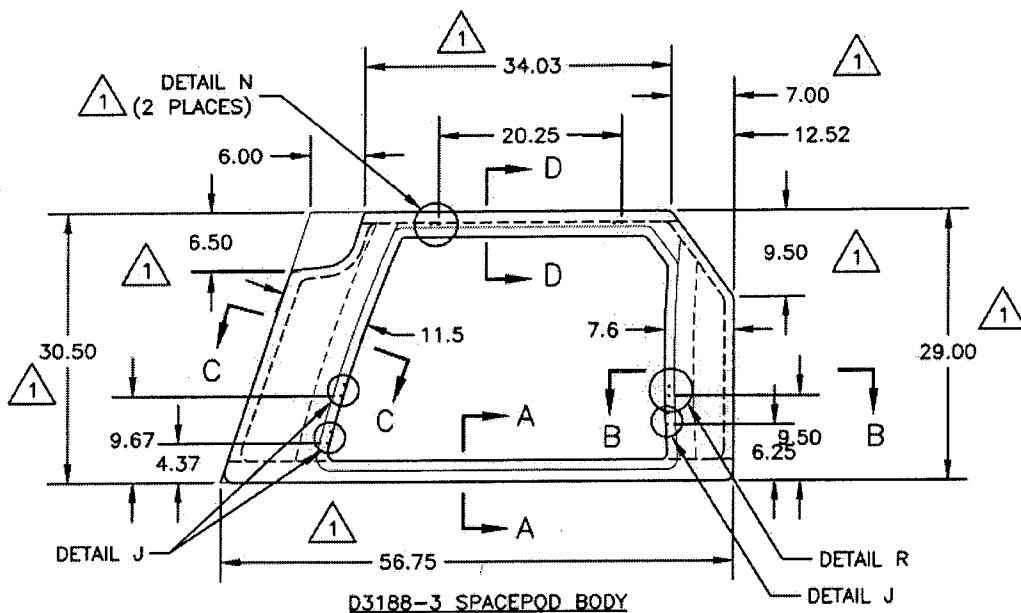
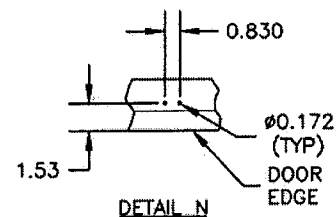
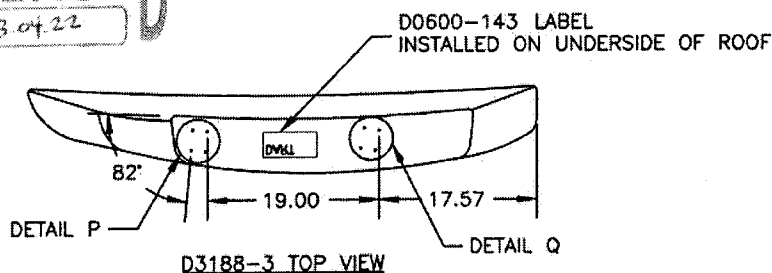
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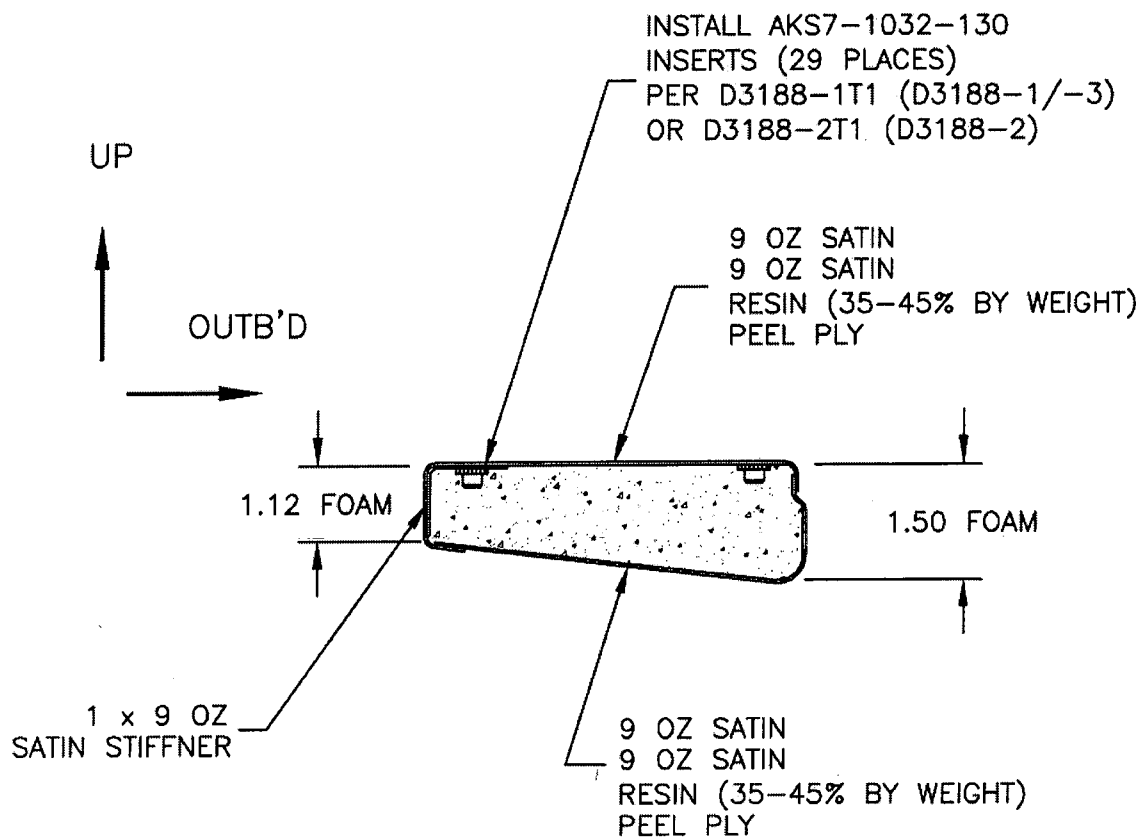
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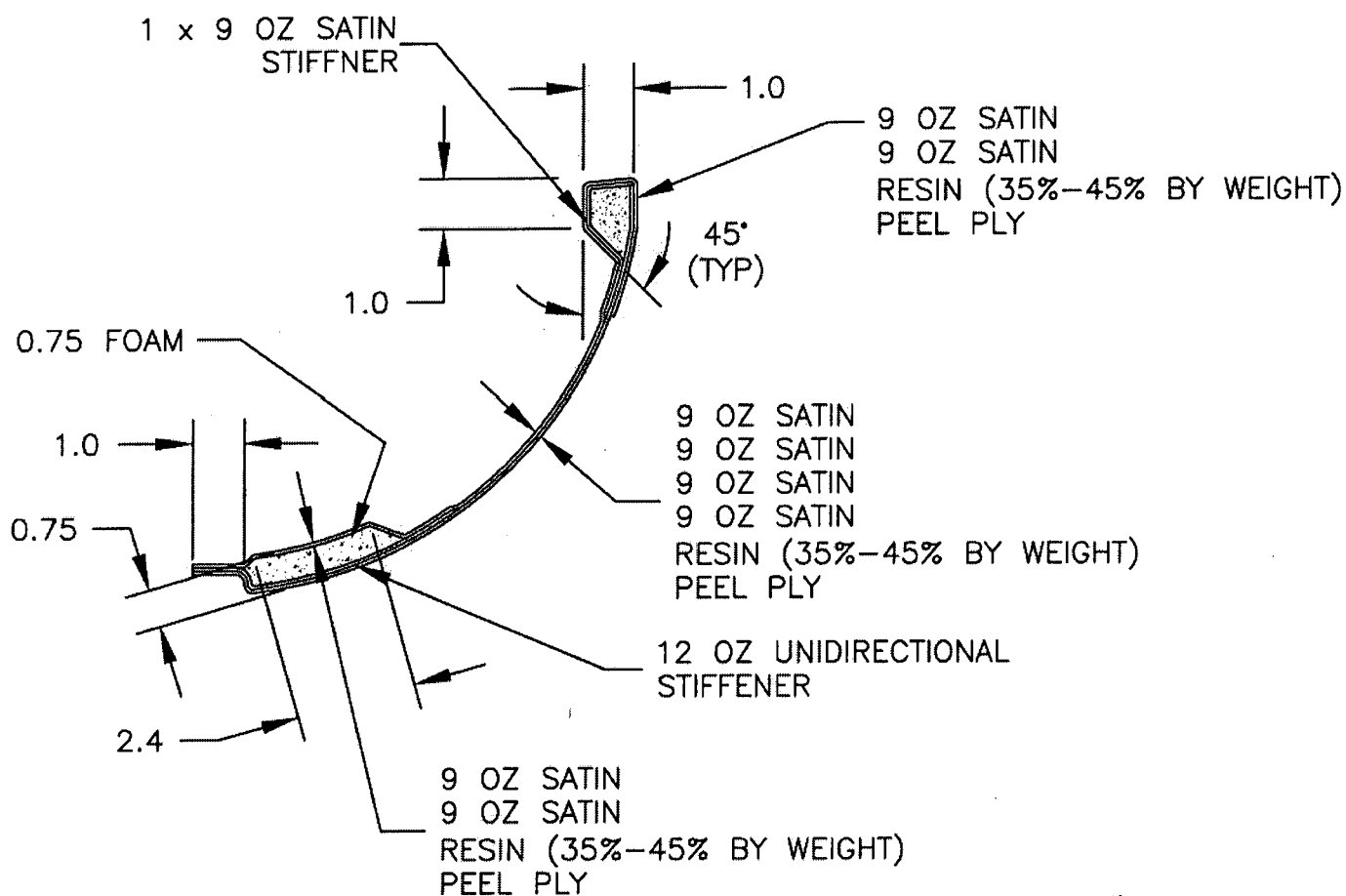
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| DATE 03.04.03 | TITLE SPACEPOD BODY | | SCALE NTS |

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SECTION B-B
(SECTION C-C SIMILAR)

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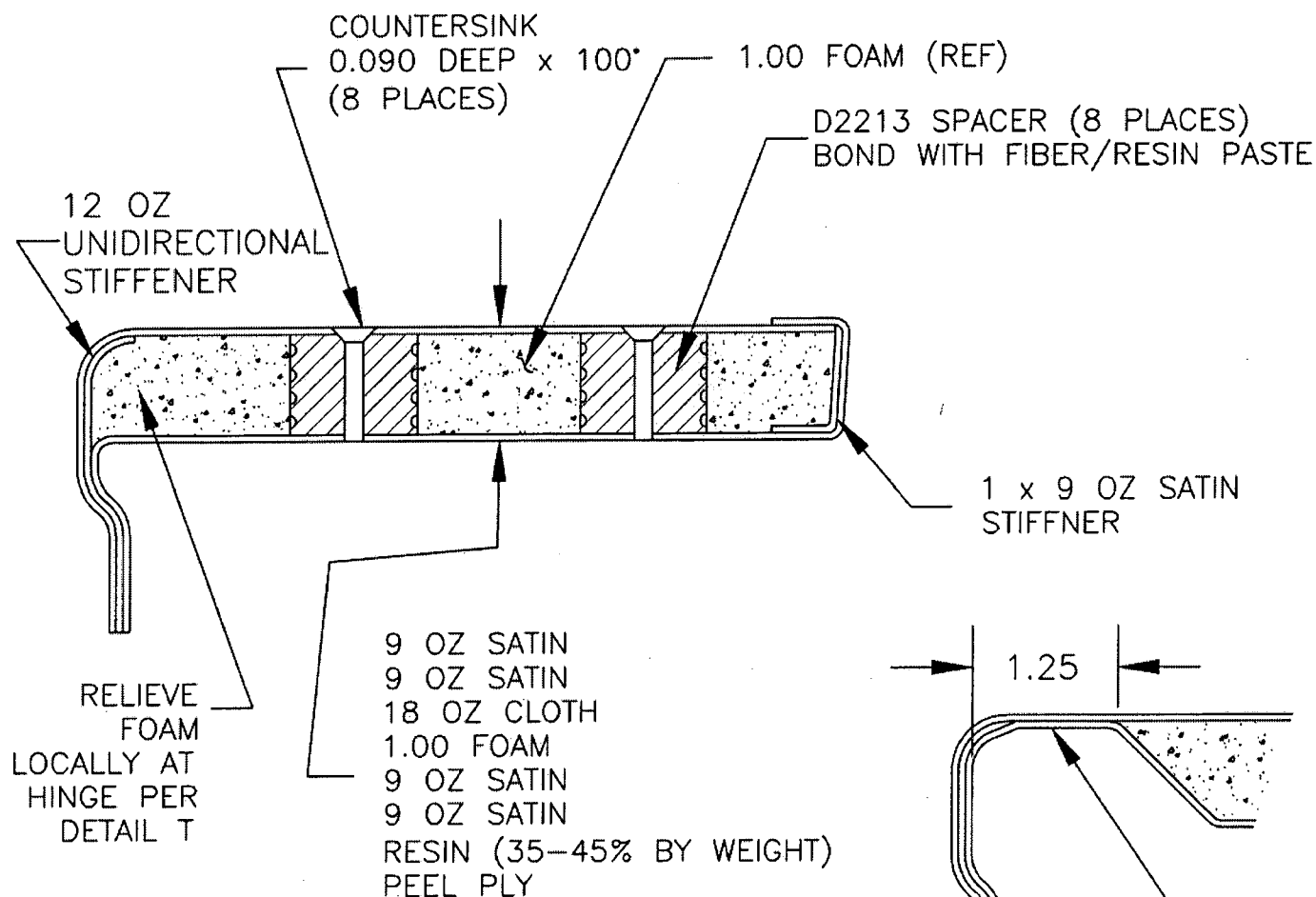
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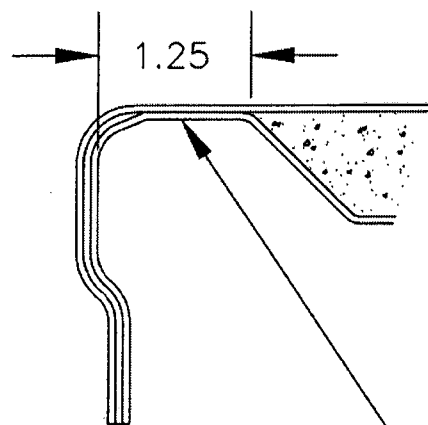
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| DATE 03.04.03 | | TITLE SPACEPOD BODY | SCALE NTS |

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(TYPICAL ROOF SECTION)

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RELIEVE AS SHOWN
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ON HINGE
DETAIL T

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Date: Wednesday, 9/27/2006 11:04:42 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SPACEPOD DOOR RH |
| Job Number : 28742B | |
| Estimate Number : 11099 | |
| P.O. Number : <i>N/A</i> | Part Number : D31862 |
| This Issue : 9/27/2006 S.O. No. : <i>N/A</i> | Drawing Number : D3186 REV A1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : A1 |
| Previous Run : 27494B | Material : <i>N/A</i> |
| Written By : | Due Date : 10/15/2006 Qty: 1 Um: Each |
| Checked & Approved By : <i>Job 09.27</i> | |
| Comment : Est Rev:A New Issue 05-11-29 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|

**Comment:** PURCHASING

Issue P/O: *2149*
 Description: D3186-2 Door
 SHIP LABEL D0600-146
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 3 Items from Previous steps

C206/09/28 ①

| | | |
|-----|---------|---------------|
| 2.0 | D31862P | Spacepod Door |
|-----|---------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

CV 9/11/08

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

m206/11/09

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock
 Location: *CA*

m206/11/09

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 9/27/2006 11:04:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 28742B

Part Number: D31862

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

SP 06/11/10

Job Completion



UO 06/11/10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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| DATE 03.03.27 | | TITLE SPACEPOD DOOR | SCALE NTS |
| A | 03.03.27 | NEW ISSUE | |
| AI | CP 04.11.04 | NEW 4.5" WIDE UNIDIRECTIONAL | |

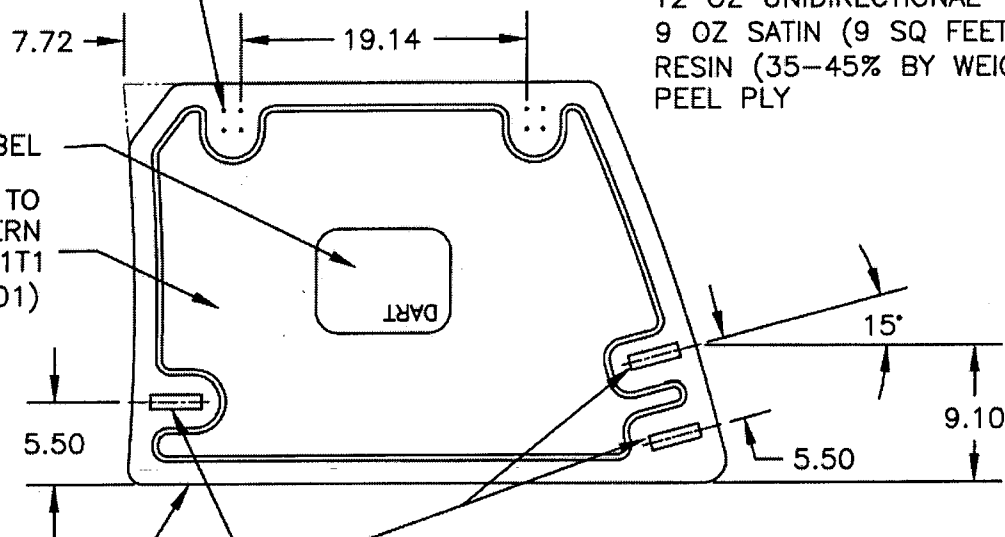
DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8005 (REFER
TO DETAIL B ON PAGE 3)

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

D0600-145 LABEL

ROUTER FOAM TO
ROUTER PATTERN
D3186-1T1
(P/N D3186-101)



12 OZ UNIDIRECTIONAL
4.5" WIDE 5" WIDE ALONG
OUTSIDE EDGE

CUT 3 PLACES AS SHOWN IN DETAIL A
ON PAGE 3

RELEASED
#03.04.27

D3186-1**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

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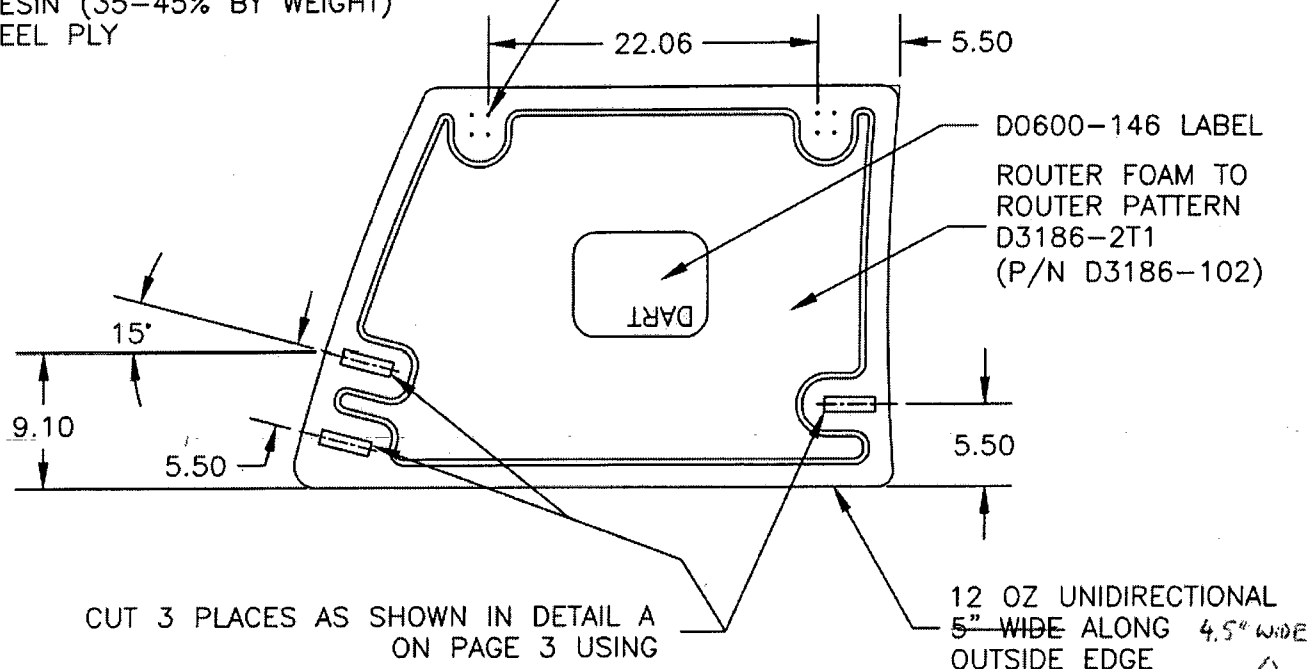


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| CHECKED # | APPROVED # | DRAWING NO. D3186 | REV. A SHEET 2 OF 3 |
| DATE 03.03.27 | | TITLE SPACEPOD DOOR | SCALE NTS |

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8006 (REFER
TO DETAIL B ON PAGE 3)



D3186-2

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

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28742E

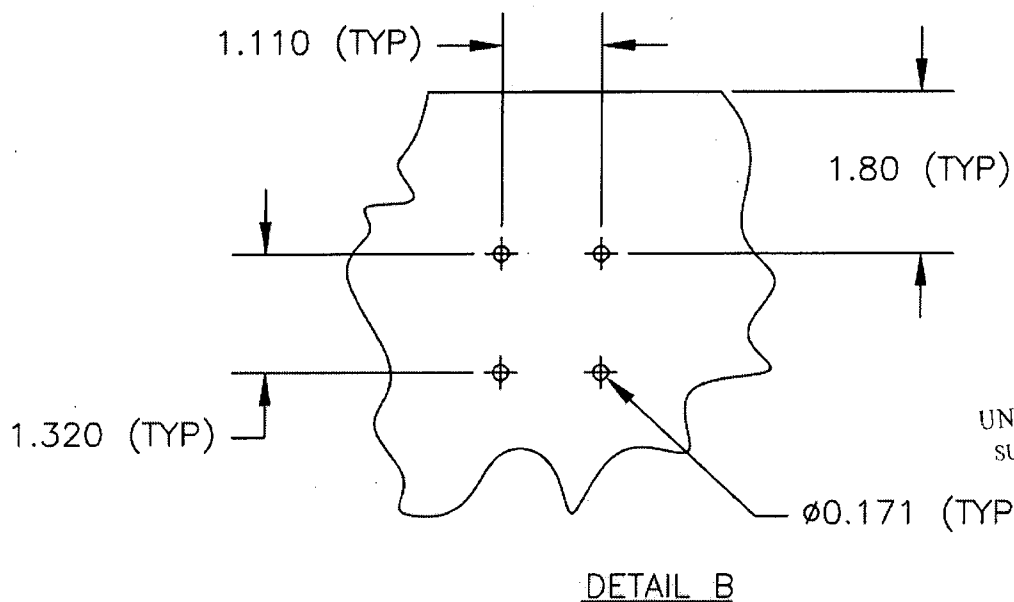
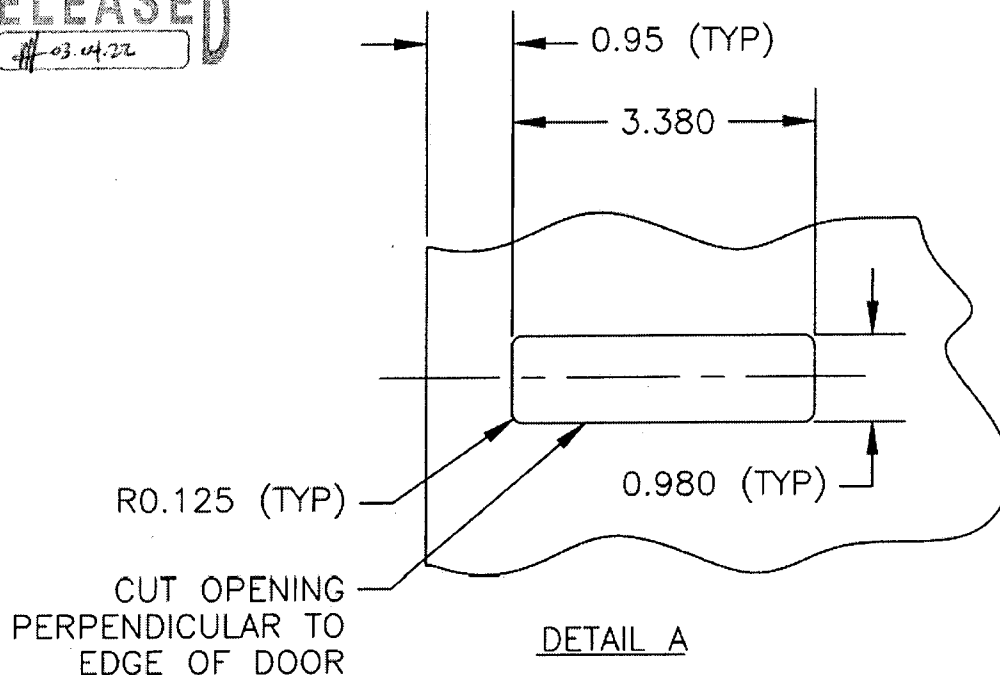
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| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY JP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED JP | DRAWING NO. D3186 | REV. A SHEET 3 OF 3 |
| DATE 03.03.27 | | TITLE SPACEPOD DOOR | SCALE NTS |

RELEASED
03.04.22



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WORK ORDER
NO. 28742B


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Date: Lundi, 2006-10-02 13:26:08
Utilisateur: Marc Dubé

Feuille de Procédé

| | | |
|--------------------------|---------------------|---|
| Client : DART | Dart Aerospace Ltd. | Nom Dessin : SPACEPOD DOOR |
| Numéro Job : 39386 | | Numéro Article : DKC134-0018 |
| Numéro Soumission : 1713 | | Numéro Dessin : D3186 |
| Numéro B.A. : | | Projet Numéro : DKC134 |
| Cette fois : 2006-10-02 | No. B.V. : | Révision dessin : A1 |
| Prsht Rev. : NC | | Matériel : Fibre 7781 et Résine 411-350 |
| Prem. fois : - - | Type : | Date Dûe : 2006-10-20 |
| Job précédente : 36733 | | Qté: 1 Udm: UNITE |

Écrit par : 

Vérifié & Approuvé par : _____

Commentaires : N° de pièce Dart Aerospace : D3186-2
N° Delastek Composites DKC-134-0018
N° de Projet Delastek: DK-362

**Inscrire le N° de
Série : B28742B Sur
la pièce**

Process Sheet Rev.: 06 Remplacer le Ac0085 par le AC0407 (
changement de fournisseur)

Produit additionnel

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|--------------|
| 1.0 | AC0303 | Frekote 44NC |
|-----|--------|--------------|


Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

| | | |
|-----|---------------|------------------------------|
| 2.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|-----|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 10/02/06 Heure Début: _____ Heure Fin: _____ Sceau: 

| | | |
|-----|--------|---------------------------------|
| 3.0 | AC0409 | Tissu à délaminer Release ply B |
|-----|--------|---------------------------------|

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

| | | |
|-----|--------|------------------------|
| 4.0 | AC0407 | Wrightlon 5200 Bleu P3 |
|-----|--------|------------------------|

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

| | | |
|-----|--------|-------------------------------------|
| 5.0 | AC0408 | Feutre de drainage N° Airweave N 10 |
|-----|--------|-------------------------------------|

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

Date: Lundi, 2006-10-02 13:26:08

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 39386

Numéro Article: DKC134-0018

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

7.0 AAC0326 9.7 oz 7781 Weave "S" glass #FG-778150-125Y

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-5456-1

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional

N° de Lot: 1-4734-1

9.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 16/10/06

Heure Début:

Heure Fin:

Sceau:



11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5659

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-5814-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 16/10/06

Heure Début:

Heure Fin:

Sceau:



Date: Lundi, 2006-10-02 13:26:09

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 39386

Numéro Article: DKC134-0018

Numéro Job:



Ség.: Machine ou Opération: Description :

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 16/10/06 Heure Début: _____ Heure Fin: _____ Sceau: GAB



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 16/10/06 Heure Début: _____ Heure Fin: _____ Sceau: GAB



Curing Début: _____ Curing Fin: _____

16.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5659

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5887-1

Date: Lundi, 2006-10-02 13:26:09

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 39386

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: 17/10/06 Heure Début: _____ Heure Fin: _____ Sceau: S.V

19.0

AAC0452

Polybond B46F

Commentair Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)
Polybond B46F N° de Lot: 1-5448-1

20.0

DKC134-0025

Foam Core N° D3186-102 (Porte D3186-2)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-102 (Porte D3186-2) N° de Lot: 1-5313-1

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0024 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 18/10/06 Heure Début: _____ Heure Fin: _____ Sceau: S.V

22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Lundi, 2006-10-02 13:26:09

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 39386

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond

Date: 18/10/06 Heure Début: _____ Heure Fin: _____ Sceau: S.V

Curing Début: _____ Curing Fin: _____

23.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5659

24.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5837-1

25.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 24/10/06 Heure Début: _____ Heure Fin: _____ Sceau: S.V

26.0 LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le lamination d'un pli de 9.7 oz.

Faire le lamination du pli de tissu de 12 oz tout le tour de la porte.

Faire le lamination du dernier pli de 9.7 oz.

Date: 24/10/06 Heure Début: _____ Heure Fin: _____ Sceau: S.V

Date: Lundi, 2006-10-02 13:26:09
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 39386

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 24/10/06 Heure Début: _____ Heure Fin: _____ Sceau: S.V. GB

Curing Début: _____ Curing Fin: _____

28.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: 26-10-06 Heure Début: _____ Heure Fin: _____ Sceau: GB

29.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer la pièce l'aide du gabarit de trimage prévu à cet effet.

Percer les " Latch " et les trous de pentures selon le dessin N° D3186

Date: 26-10-06 Heure Début: _____ Heure Fin: _____ Sceau: GB

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 39386

Nom Dessin: SPACEPOD DOOR

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

30.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-5535-1

31.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)

Dupont Activator N° 7975S

N° de Lot: 1-5692-1

32.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: 1-5535-3

33.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.

Application primer

NOV 02 2006

Laisser sécher pendant 3 heures.



Date: 27-10-06 Heure Début: _____ Heure Fin: _____ Sceau: 673

35.0

FINITION 3.

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

FINITION PIÈCE DART

28/10/06



Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Date: Lundi, 2006-10-02 13:26:09

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 39386

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

36.0

AAC0450

Label N°D0600-146

Commentair Qty.: 1 UNITE(s)/Unit

Total: 1 UNITE(s)

Label N°D0600-146

N° de Lot:

1-5816-2

37.0

AAC0444

Surface Veil

Commentair Qty.: 0.08 VERGE(s)/Unit

Total: 0.08 VERGE(s)

Surface Veil

N° de Lot:

2817

38.0

AAC0501

Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit

Total: 0.015 GALLON(s)

Résine Mia-Poxy

N° de Lot:

1-5721-1

39.0

AAC0502

Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTÉ(s)/Unit

Total: 0.030 PINTÉ(s)

Durcisseur 95 Pour Résine Mia-Poxy

N° de Lot:

1-5721-2

40.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run: 15.0000Hrs
FABRICATION GÉNÉRALE DART

Coller le Label N° 0600-146 selon les séquences suivantes:

- 1 Surface Veil
- 2- Label
- 3- Surface Veil

À l'aide de la résine Mia-Poxy selon le dessin D3186.

Laisser sécher pendant 6 heures.

Date:

31/10/06

Heure Début:

Heure Fin:

Sceau:

68

41.0

AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit

Total: 0.050 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot:

1-5675-1

42.0

AC0059

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit

Total: 0.039 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

43.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 39386

Numéro Article: DKG134-0018

Numéro Job:



Séq.: Machine ou Opération: Description:

Date: 07/11/06 Heure Début: _____ Heure Fin: _____ Sceau: 613 07-11-06



44.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5535-1

45.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-5092-1

46.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5535-3

47.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MATÉRIELNettoyages Qty 1 06-11-06
Relaver 2- Nettoyages Qty 1 07-11-06

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
APPLICATION DE PRIMER

Masquer le label.

Appliquer une deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.

Application de primer.

NOV 07 2006

NOV 06 2006

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



49.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
INSPECTION PIÈCE DART

1x 8 nov 06



Emballage QT 1 8 nov 06



Date: Wednesday, 9/27/2006 11:04:38 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SPACEPOD BODY RH |
| Job Number : 28742A | |
| Estimate Number : 11102 | |
| P.O. Number : <i>N/A</i> | Part Number : D31882 |
| This Issue : 9/27/2006 S.O. No. : <i>N/A</i> | Drawing Number : D3188 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 27494A | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 10/15/2006 Qty: 1 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 06.09.27 | |
| Comment : Est Rev:A New Issue 05-11-29 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------|-----------------|
| 1.0 | D2213 | Aluminum Spacer |
|-----|-------|-----------------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

| | | |
|---|-------|--------|
| 8 | D2213 | Spacer |
|---|-------|--------|

Batch: *B 22997A* *C Loc 06/09/28* *(B)*

| | | |
|-----|----|------------|
| 2.0 | PG | PURCHASING |
|-----|----|------------|

**Comment:** PURCHASINGIssue P/O: *2149**C Loc 06/09/28* *(1)*

Description: D3188-2 BODY

SHIP LABEL D0600-142 & D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

| | | |
|-----|---------|---------------|
| 3.0 | D31882P | Spacepod Body |
|-----|---------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

[Signature] 06/11/08

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 9/27/2006 11:04:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 28742A

Part Number: D31882

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 06/11/09

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

ml 06/11/09

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ml 06/11/10

Job Completion



in 06/11/10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries



| | | | |
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3188 | REV. A SHEET 1 OF 7 |
| DATE 03.04.03 | | TITLE SPACEPOD BODY | SCALE NTS |
| A | 03.04.03 | NEW ISSUE | |

RELEASED
#-0304.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

| <u>PART</u> | <u>LAYUP</u> | <u>TRIM AND DRILL</u> |
|-------------|--------------|-----------------------|
| D3188-1 | DT8003 | DT8501 |
| D3188-2 | DT8004 | DT8502 |
| D3188-3 | DT8500 | DT8501 |

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

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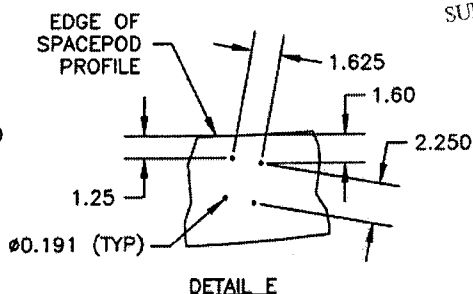
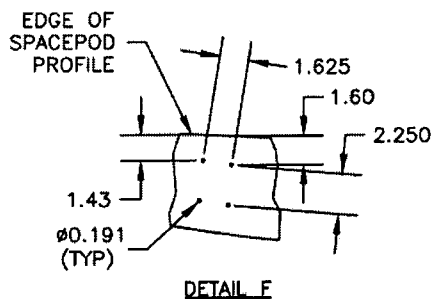
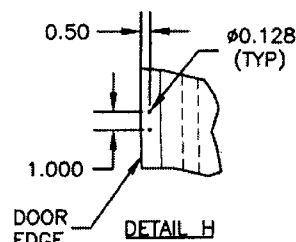
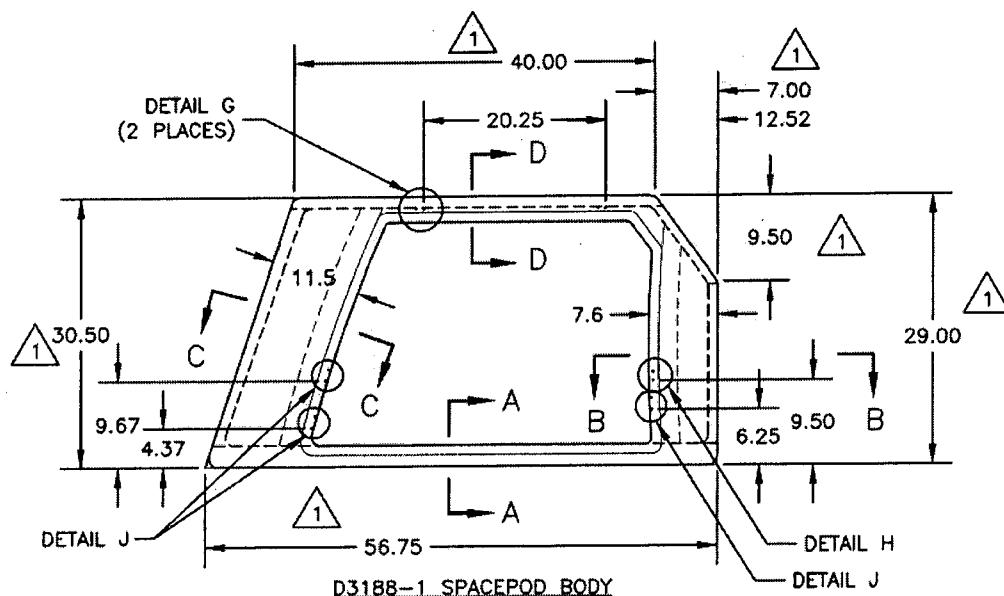
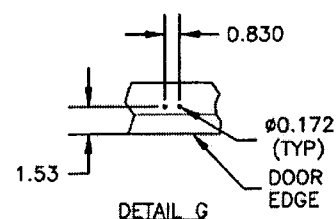
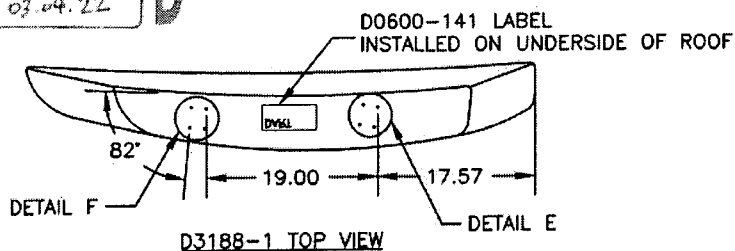
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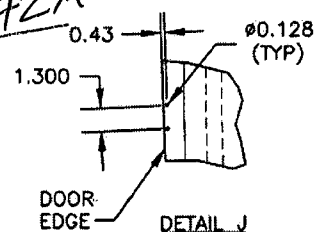


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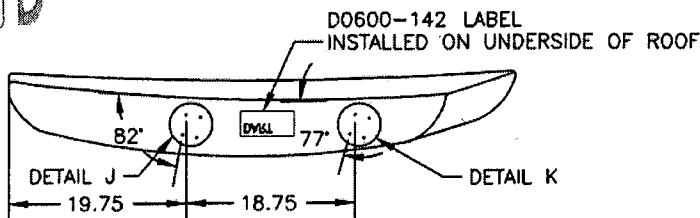
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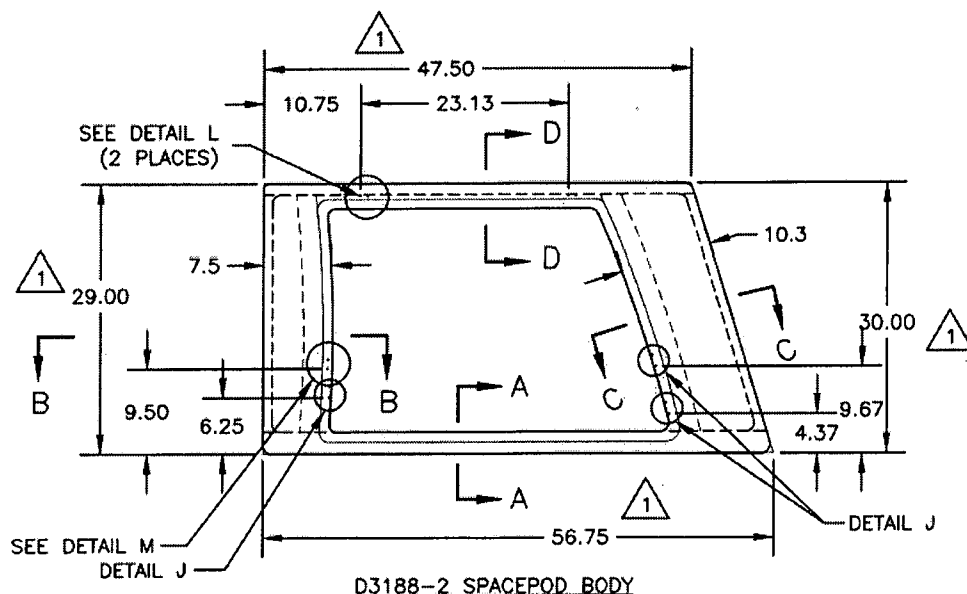


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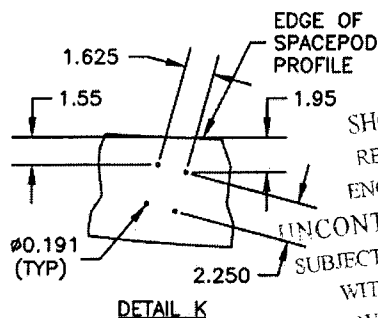
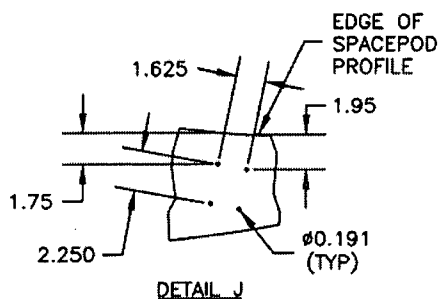
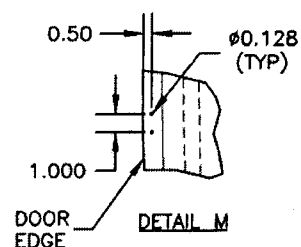
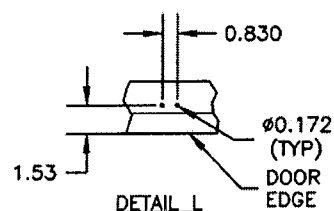
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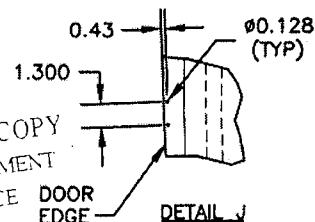
D3188-2 TOP VIEW



D3188-2 SPACEPOD BODY



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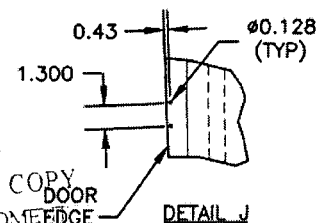
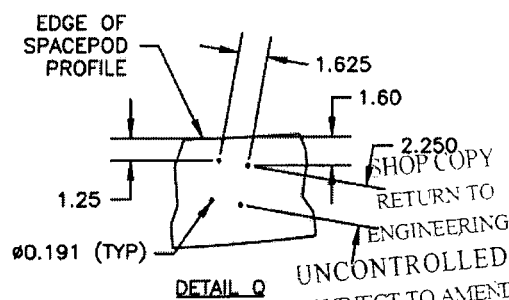
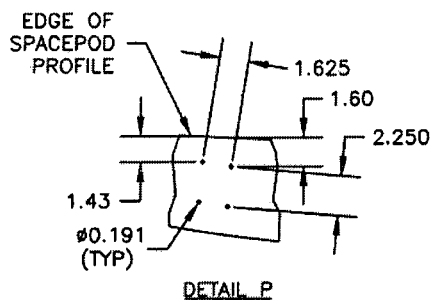
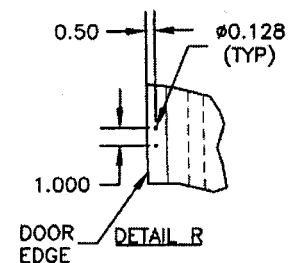
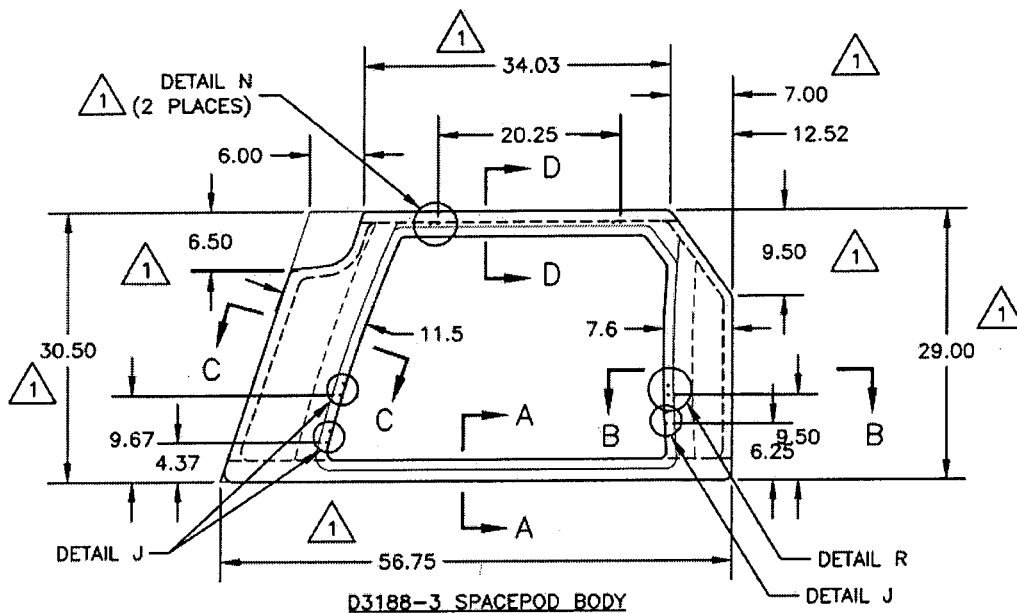
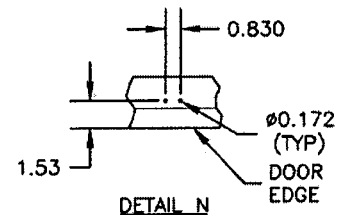
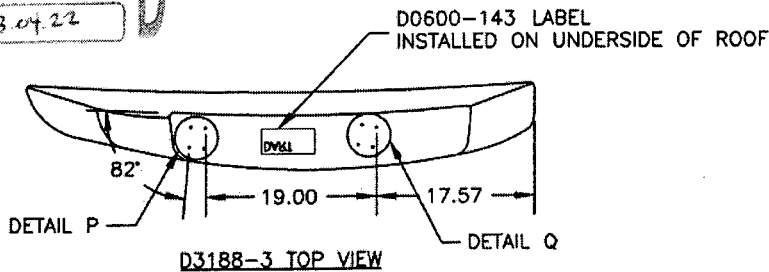


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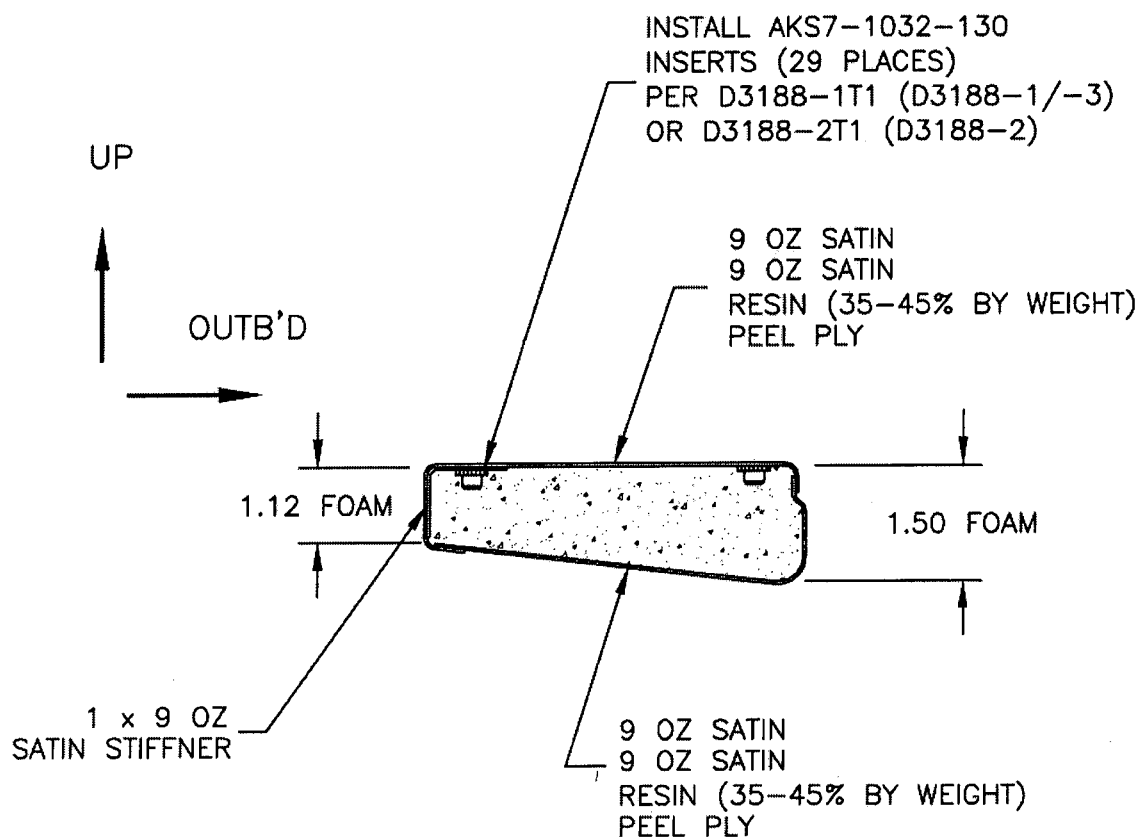
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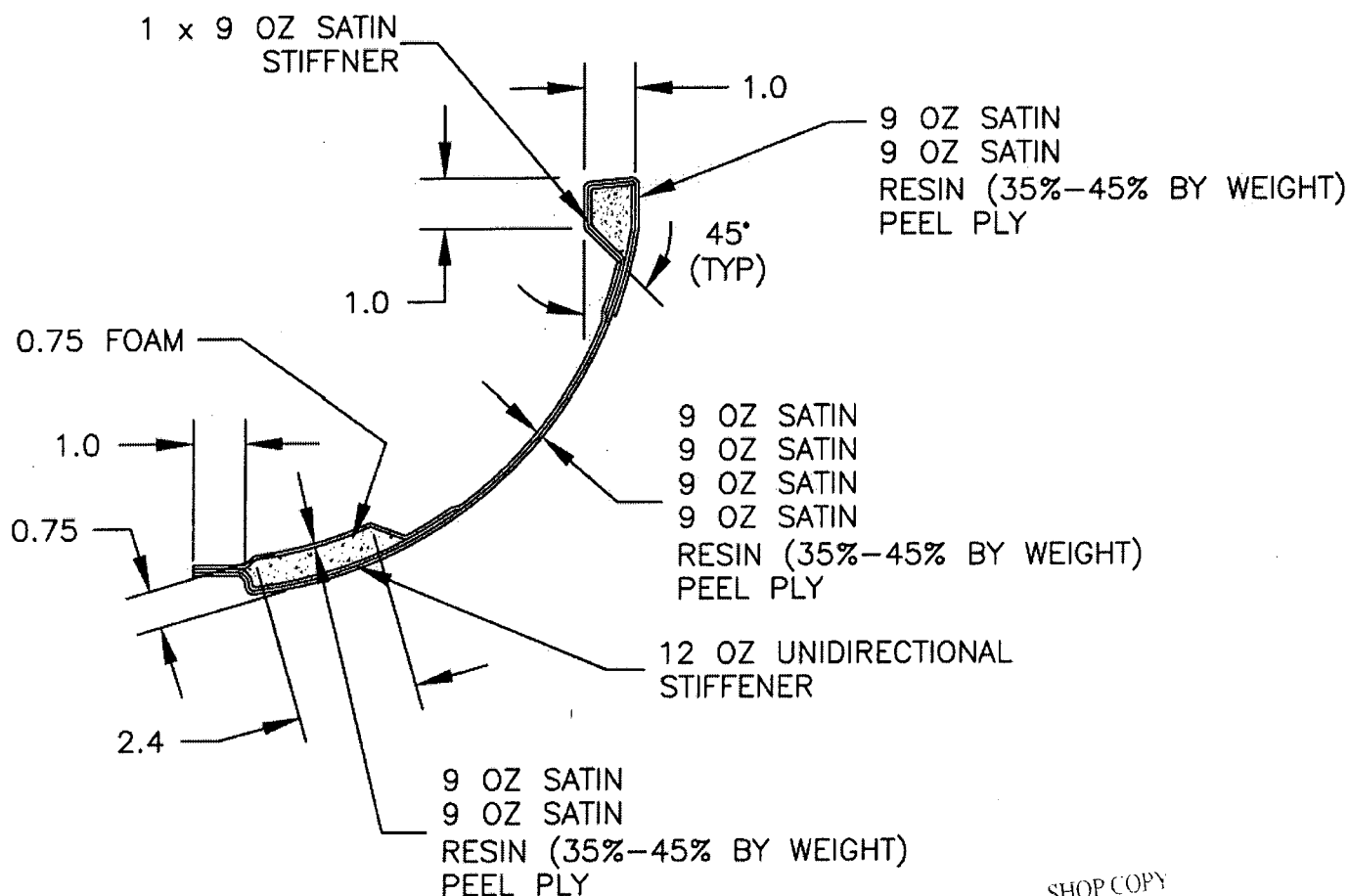
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03.04.29
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(SECTION C-C SIMILAR)

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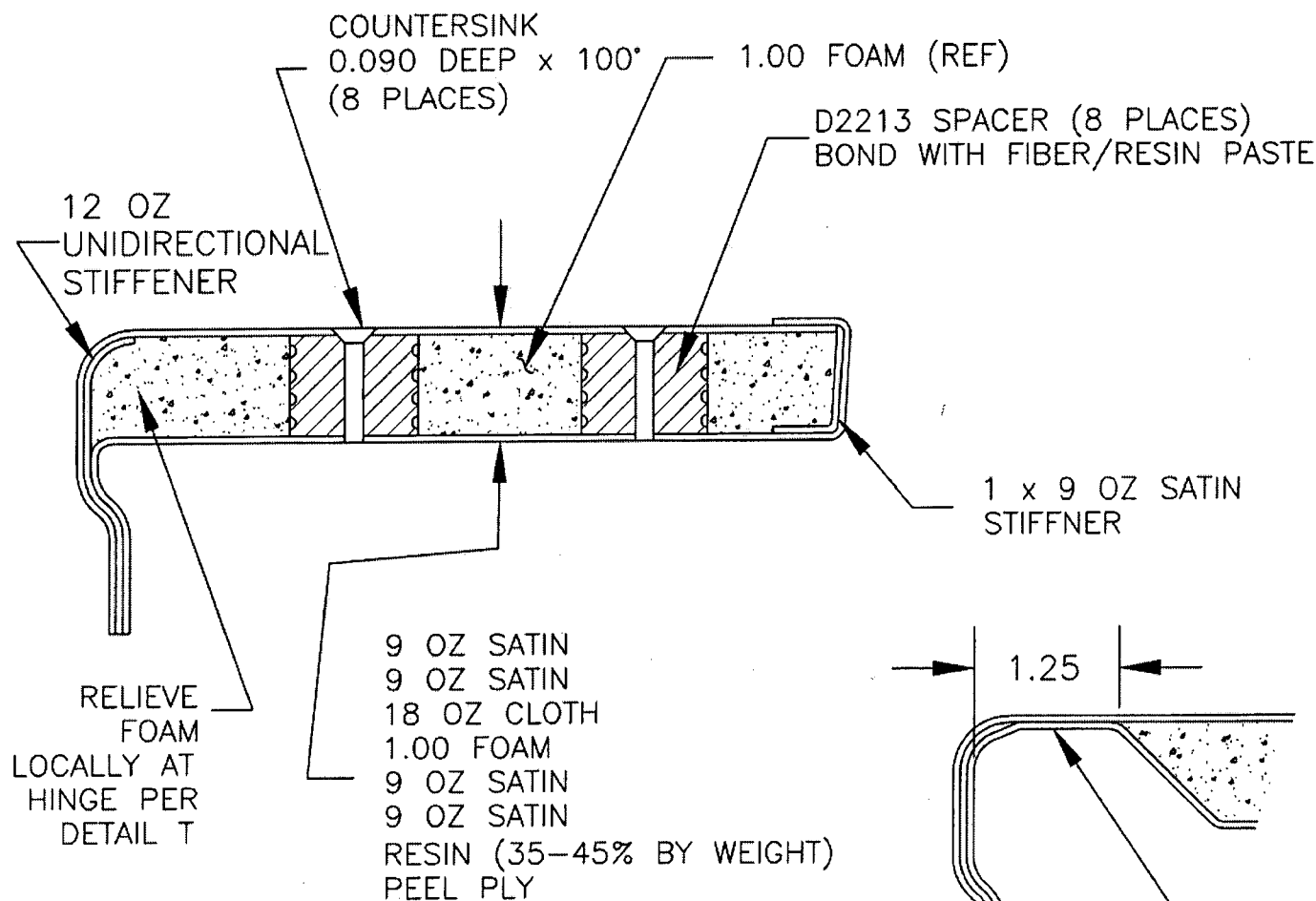
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DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

| | |
|------------|-------|
| Invoice # | 11341 |
| Customer # | DART |

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

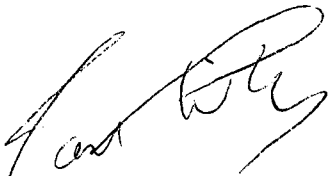
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

| | | | | | | | |
|--|------------|---------------|-------------|---|------------|--------------------------|-----------|
| Ship via | | F.O.B. | | Terms | | Salesperson | |
| Delastek Composites | | Origin | | Net30 days | | Claude Lessard, ext. 233 | |
| Ship date | Order Date | Our PO # | Order by | | Your PO # | | GST/PST # |
| 08/11/06 | 28/09/06 | 4912 | C. Lavoie | | PO00002149 | | |
| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | | | |
| 1 | 0 | 1 | DKC134-0019 | D3188-1 Spacepod Body LH B28741A Job: 40222 | | | |
| 1 | 0 | 1 | DKC134-0017 | D3186-1 Spacepod Door LH B28741B Job: 39388 | | | |
| 1 | 0 | 1 | DKC134-0020 | D3188-2 Spacepod Body RH B28742A Dwg. D3188-2 Rév.: A Job: 39385 | | | |
| 1 | 0 | 1 | DKC134-0018 | D3186-2 Spacepod Door RH B28742B Dwg. D3186-2 Rév.: A1 Job: 39386 | | | |
|  | | | | | | | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mardi, 2006-11-07 14:37:41
 Utilisateur: Marc Dubé

Feuille de Procédé

 Client : DART Dart Aerospace Ltd.
 Numéro Job : 40222
 Numéro Soumission : 1714
 Numéro B.A. :
 Cette fois : 2006-11-07 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente : 39826

 Nom Dessin : SPACEPOD BODY
 Numéro Article : DKC134-0019
 Numéro Dessin : D3188
 Projet Numéro : DKC134
 Révision dessin : A
 Matériel : Fibre 7781 et Résine 411-350
 Date Dûe : 2006-11-14 Qté: 1 Udm: UNITE

 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Dart Aerospace : D3188-1
 N° Delastek Composites DKC-134-0019
 N° de Projet Delastek: DK-362

 Inscrire le N° de
 Série : B28741A Sur
 la pièce

 Process Sheet Rev.: 05 Remplacer le AC0085 par le AC0407 (
 changement de fournisseur)

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

 Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MOULE

 Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon
 le QSI-006.

Date: 13/10/06 Heure Début: _____ Heure Fin: _____ Sceau: GB

3.0 AC0409 Tissu à délaminer Release ply B

 Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
 Tissu à délaminer Release ply B

4.0 AC0407 Wrighton 5200 Bleu P3

 Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
 Wrighton 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
 Feutre de drainage N° Airweave N 10

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019.

Numéro Job:



Séq.: Machine ou Opération: Description:

6.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total: 7.00 VERGE(s)
Stretchlon 200 poche à vide Vert

7.0 AAC0326 9.7 oz 7781 Weave "S" glass #FG-778150-125Y

Commentair Qty.: 11.4 VERGE(s)/Unit Total: 11.4 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-5456-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-4734-1

10.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s)
WR1850 ROVING 18 OZ x 50" N° de Lot: 1-5283-1

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 13/10/06 Heure Début: _____ Heure Fin: _____ Sceau: GB

12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTÉ(s)/Unit Total: 0.0640 PINTÉ(s)
Catalyst N° DDM-9 N° de Lot: 5659

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-5814-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Date: Mardi, 2006-11-07 14:37:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40222

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0019

Numéro Job:



Séq.: Machine ou Opération: Description :

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxxy 66.

Date: 13/10/06 Heure Début: _____ Heure Fin: _____ Sceau: GB

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 13/10/06 Heure Début: _____ Heure Fin: _____ Sceau: GB



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: 13/10/06 Heure Début: _____ Heure fin: _____ Sceau: GB



Curing Début: _____ Curing Fin: _____

Date: Mardi, 2006-11-07 14:37:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:



Séq.:

Machine ou Opération:

Description :

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot:

2-4483-3

19.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date:

18/10/06

Heure Début:

Heure Fin:

Sceau:



20.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-5837-1

21.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot:

5659

22.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le
Foam Core.

18/10/06

23.0

AAC0452

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot:

1-5448-1

24.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

À l'aide de polybond, coller ensemble les deux surfaces scellées

Date: Mardi, 2006-11-07 14:37:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:




Séq.:

Machine ou Opération:

Description :

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1 Date: 19/10/06 Sceau: 

Quantité: Date: Sceau: GB


25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: 23/10/06 Sceau: 

Quantité: Date: Sceau: GB

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5837-1

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5659

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL DARTFaire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core

Date: Mardi, 2006-11-07 14:37:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40222

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0019

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Laisser sécher pendant 2 heures minimum.

Date: 24/10/06

Sceau: _____

Initiales: GB



30.0

AAC0452

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 1-5448-1

31.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: 24/10/06

Heure Début: _____

Heure Fin: _____

Sceau: _____



32.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÉCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 24/10/06

Heure Début: _____

Heure Fin: _____

Sceau: GB



33.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: 24/10/06

Heure Début: _____

Heure Fin: _____

Sceau: GB



Curing Début: _____

Curing Fin: _____

Date: Mardi, 2006-11-07 14:37:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5675-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond.

Date: 25/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

25/10/06



38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5837-1

39.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5659

40.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

Date: Mardi, 2006-11-07 14:37:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: _____ Date: _____ Sceau: _____

Quantité: 1 Date: 25/10/06 Sceau: _____

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5659

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5837-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 26/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____

44.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 26/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____

45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage

Date: Mardi, 2006-11-07 14:37:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40222

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0019

Numéro Job:



Séq.: Machine ou Opération: Description :

4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 26/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____

Curing Début: _____ Curing Fin: _____



46.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 27/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



47.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Perçer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, perçer les 8 dégagement de ø .745" pour les spacers. (Ne pas perçer la peau extérieur de la pièce)

Date: 27/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



48.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5659

49.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5837-1

Date: Mardi, 2006-11-07 14:37:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40222

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0019

Numéro Job:



Séq.: Machine ou Opération: Description :

50.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total-Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 30/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



52.0 AAC0448 Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5816-1

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers.pour reboucher les trous.

Appliquer un pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

Date: 30/10/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

54.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5659

Date: Mardi, 2006-11-07 14:37:42

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:



Séq.:

Machine ou Opération:

Description :

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot.:

1-5837-1

56.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date:

3/10/06

Heure Début:

Heure Fin:

Sceau:



57.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date:

3/10/06

Heure Début:

Heure Fin:

Sceau:



Curing Début:

Curing Fin:

58.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

FINITION PIÈCE DART

Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

Percer les 8 trous des spacers afin de les déboucher.

Quantité:

1

Date:

06/11/06

Sceau:



Quantité:

Date:

Sceau:

Date: Mardi, 2006-11-07 14:37:42

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:



Séq.:

Machine ou Opération:

Description :

59.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)

Dupont Primer N° 1104S

1-5535-1

60.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTÉ(s)/Unit Total : 1.0000 PINTÉ(s)

Dupont Activator N° 7975S

1-5692-1

61.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)

Dupont Reducer N° 12375S

1-5535-3

62.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

Date: NOV 07 2006

Heure Début: — Heure Fin: — Sceau:



64.0

AAC0445

Label N° D0600-141

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Label N° D0600-141

N° de Lot:

1-5816-3

65.0

AAC0501

Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total : 0.015 GALLON(s)

Résine Mia-Poxy

N° de Lot:

1-5721-1

66.0

AAC0502

Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTÉ(s)/Unit Total : 0.030 PINTÉ(s)

Durcisseur 95 Pour Résine Mia-Poxy

N° de Lot:

1-5721-2

67.0

AAC0444

Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)

Surface Veil

N° de Lot:

2817

Date: Mardi, 2006-11-07 14:37:42

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019

Numéro Job:



Séq.: Machine ou Opération: Description:

68.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-141 sur le spacepod en plaçant un suface veil eu dessous et par dessus le label à l'aide de résine Mia Poxy selon I.F. # DKC134-0019-13

Date: 6/11/06 Heure début: _____ Heure fin: _____ Sceau: _____



69.0

AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5824-1

70.0

AC0059

Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

71.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 8/11/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



72.0

AAC0671

Dupont Primer N° 1104S

Commentaire Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-5535-1

73.0

AAC0670

Dupont Activator N° 7975S

Commentaire Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)

Dupont Activator N° 7975S

N° de Lot: 1-5692-1

74.0

AAC0672

Dupont Reducer N° 12375S

Commentaire Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: 1-5535-3

75.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

PRÉPARATION DU MATÉRIEL

Masquer le label.

Nettoyage qty 1 07-11-06
Nettoyage qty 1 08-11-06



Date: Mardi, 2006-11-07 14:37:42

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40222

Numéro Article: DKC134-0019.

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

76.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

Date: NOV 08 2006

Heure Début: _____

Heure Fin: _____

Sceau: _____



77.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 8 nov 06

Sceau: _____

Initiales: *MD*

Emballage QT 1 8 nov 06

